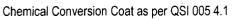
Dart Aerospace Ltd. Wednesday, 3/8/2006 10:44:26 AM Kim Johnston User: **Process Sheet Drawing Name** : PLACARD #: CU-DAR001 Dart Helicopters Services Customer Job Number : 26148 **Estimate Number** : 11149 NA : D32141 Part Number P.O. Number S.O. No. :NA **Drawing Number** : D3214 REVA1 : 3/8/2006 This Issue : N/A Project Number Prsht Rev. · NA : MACHINED PARTS : A1 Type **Drawing Revision** First Issue : NIA NIGH: Material **Previous Run Due Date** : 3/20/2006 Qty: 10 Um: Written By Checked & Approved By Comment **Additional Product** Job Number: Description: Seq. #: **Machine Or Operation:** 1.0 M5052H32S080 5052-H32 .080 Sheet Comment: Qty.: 0.7802 sf(s)0.0780 sf(s)/Unit Total: 5052-H32 .080 Sheet Material: 5052-H32/H34 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Identify for D3214-1 06/03/09 Batch: M 19725 2.0 SHEAR SHEAR Comment: SHEAR Cut blanks: 3.70" x 2.70" Drill hole and fillet corner as per Dwg D3214 Deburr Identify as D3214-1 INSPECT WORK TO CURRENT STEP 3.0 QC5 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING1 HAND FINISHING RESOURCE #1 4.0



Comment: HAND FINISHING RESOURCE #1





POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3



06203314



Each

5.0

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W/O:			WC	RK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•		·				
Part No		PAR #:	Fault Cate	gory: No	CR: Yes	DQA:	∑ Date: ₫	6/04/06
					QA: N/0	C Closed:	Date:	
NCR:			WORK ORDE	ER NON-CONFORMANC	E (NCR)			
DATE	STEP	Description of NC	Corrective Action Section B Initial Action Description		Sign &	Verification	Approval	Approval
		Section A	Chief Eng	Chief Eng	Date	Section C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Wednesday, 3/8/2006 10:44:26 AM Date: • User: Kim Johnston **Process Sheet** Drawing Name: PLACARD Customer: CU-DAR001 Dart Helicopters Services Part Number: D32141 Job Number: 26148 Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT POWDER COAT/CHEMICAL CONVERSION 6.0 10 03 04 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 7.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Engrave text as per Folio FA394 and Dwg D3214 INSPECT PARTS AS THEY COME OFF MACHINE 8.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 9.0 QC8 06/04/04 Comment: SECOND CHECK 10 PACKAGING RESOURCE #1 10.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock St 416 Location: DOCUMENT CONTROL 11.0 DC Comment: DOCUMENT CONTROL Inspection Level 21 w destros Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		. =							
Part No			· · · · · · · · · · · · · · · · · · ·						

QA: N/C Closed: _____ Date: _____

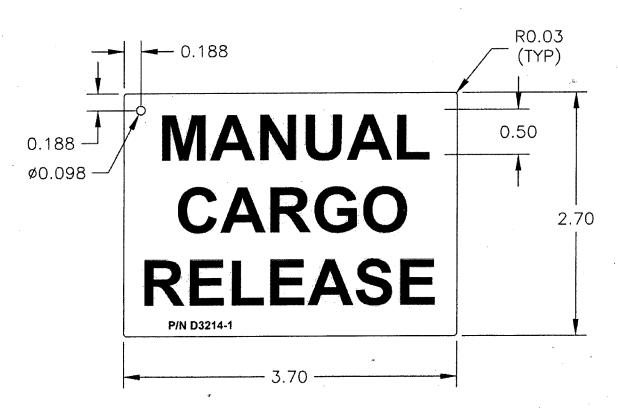
NCR:		W	WORK ORDER NON-CONFORMANCE (NCR)						
	STEP	Description of NC	Corrective Action Section B			Varification			
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries





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DESIG	n drawn by	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	7.7
CHECK	(EQ. APPROVED	DRAWING NO.	REV. A
	# #	D3214	SHEET 1 OF 1
DATE	<u> </u>	TITLE	SCALE
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Α	, 04.01.27	NEW ISSUE	
Δ,	A 10 04 05 14	Conner Tree: 43 LAS 41	



NOTES

1) MATERIAL: 5052-H32 /H34 (QQ-A-250/8) 0.080 THICK (M5052H32SM80)OPY

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSINODSENAND

3) ENGRAVE LETTERS (0.50" HEIGHT) AS SHOWN AFTER POWDER CONTROLLED COPY 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT

5) ALL DIMENSIONS ARE IN INCHES

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